

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020064**Date Inspected:** 10-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Liu Hua Jie, Lu Li Qing, Geng W			<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No N/A
				<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Orthotropic Box Girder( OBG)	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12AW.

During Random Visual in process Inspection, this QA inspector observed Crack like indications at Side plate to bottom plate welds in Back gauged area in Segment 12AW. Welds are identified as SEG3004A-010, 06. This QA inspector informed ZPMC Quality control (QC) Inspector about this. ZPMC NDT personnel performed Magnetic Particle Testing (MT) on above mention welds & confirmed all the indications. ZPMC QC "Liu Hua Jie" agreed remove all the indications before welding.

Assembly, Bay 14, 12AW, Bottom Plate to Side Plate.

SMAW welding of weld joint SEG3004A-004; located on assembly, Bay 14, 12AW. Welder is identified as 66258; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-B-U2-FCM-1.

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Assembly, Bay 14, SEG072, 11DE.

FCAW welding of weld joint SSD16-PP104-024, 025; located on assembly, Bay 14, 11DE. Welder is identified as 058551; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4C-F.

This QA Inspector carried out NDE on following

Subassembly, Bay 19, OBG Suspender Brackets.

This QA inspector performs Random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005302). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

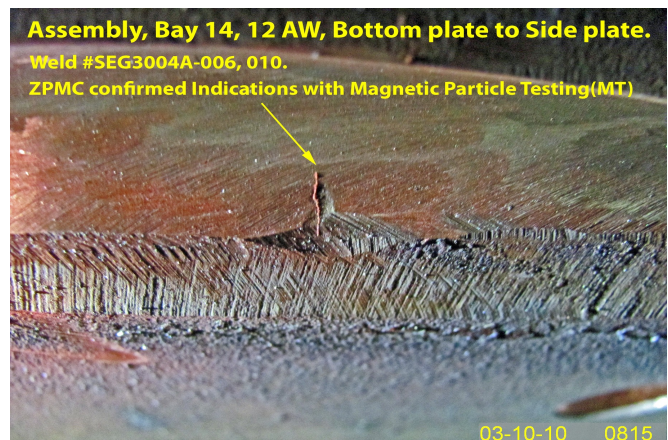
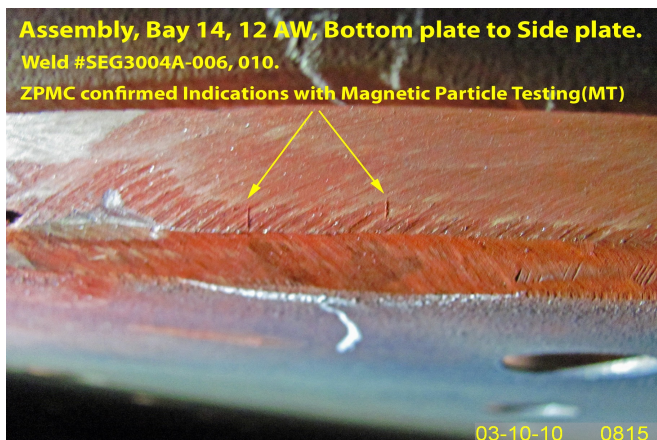
- 1)SB008-046-025, 031, 037, 043, 049, 055, 061, 067, 011, 018, 001, 004, 005, 007, 008, 019, 020.
- 2)SB008-046-006, 077, 017, 009, 010, 012 TO 016, 026, 032.

Subassembly, Bay 14, OBG STIFFNER.

This QA inspector performs Random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005301). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1)CA061.
- 2)CA089.
- 3)CA091.
- 4)CA091.
- 5)SEG51D.

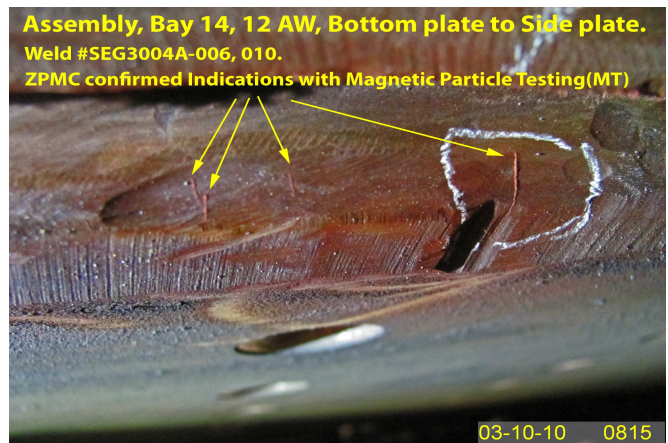
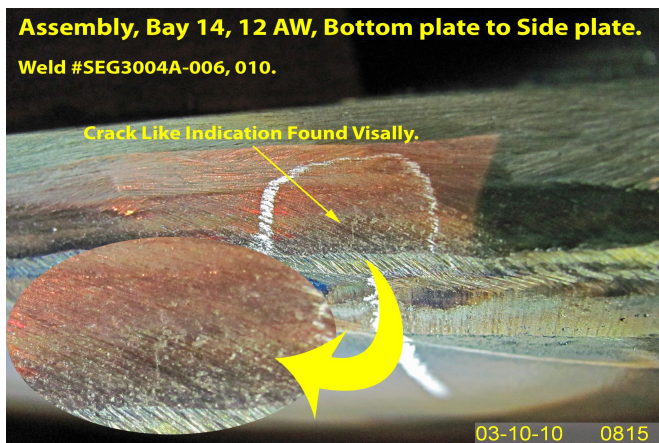
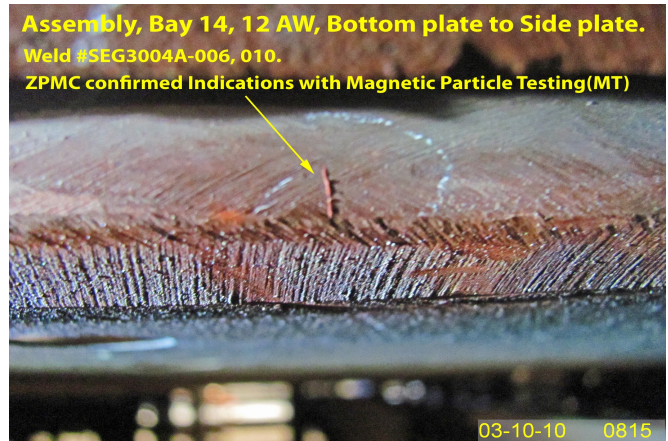
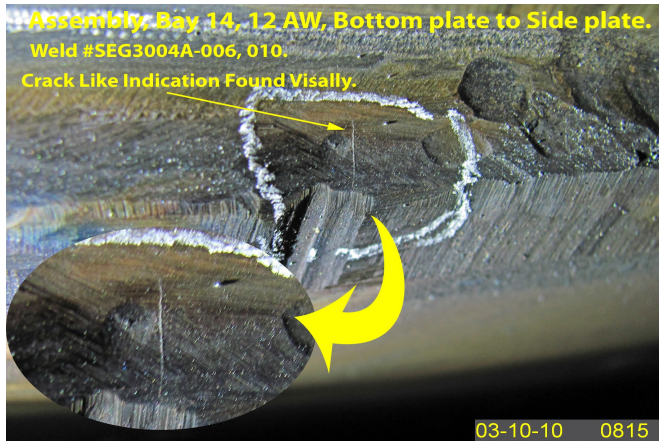
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





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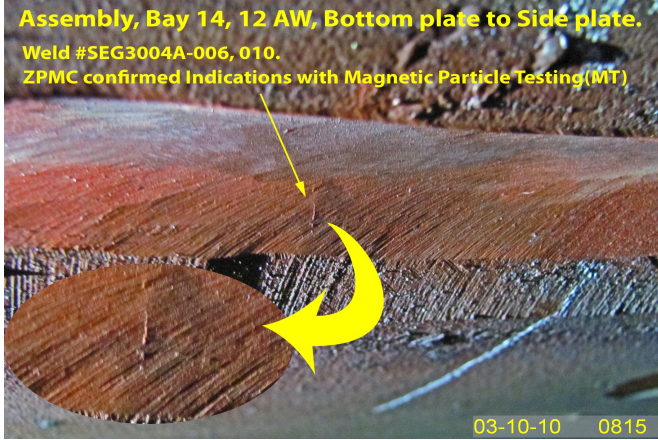


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### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Miller,Mark
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QA Reviewer
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